

Date: Friday, 01/08/2008 3:32:40 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: HEADREST ADAPTER
Job Number	: 40980 <i>2</i>	Part Number	: D3773041
Estimate Number	: 13333	Drawing Number	: D3773 REV B
P.O. Number	:	Project Number	:
This Issue	: 01/08/2008 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: 1/1 Type : SMALL / MED FAB	Due Date	: 21/08/2008
Previous Run	: 05004	Qty:	32 Um: Each
Written By	:		
Checked & Approved By	: <i>JLD 08-08-05</i>		
Comment	: Est Rev:A 08-05-21 new issue DD verified by:ec Est Rev:B 08-07-18 revB as per dwg DD verified by:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Pick Packing Kit

2.0	D37731	Adapter
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 32.0000 Each(s)  
 Adapter  
 batch: *B40996*

*408-08-21*

3.0	D37733 <i>machinist</i>	Leg
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 32.0000 Each(s)  
 Leg  
 batch: *B40997*

*408-08-21*

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- locate top hole with a 3/16" dowel pin and tack weld D3773-1 adapter to D3773-3 leg as per dwg D3773  
 \*\*\*\*take dowel pin out before welding\*\*\*\*

2- weld as per dwg D3773 QSI004  
 304 S.S. Welding Rod Batch: *M106762*

3- if necessary grind interior of D3773-3 leg flush after welding

*408-08-21*



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Drawing Name: HEADREST ADAPTER

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Part Number: D3773041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*006021 (x8)*

*PD 08-08-21 (8)*

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 08-08-21 (8)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location *60*

*8/8/05*

*(8K)*

*scf*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

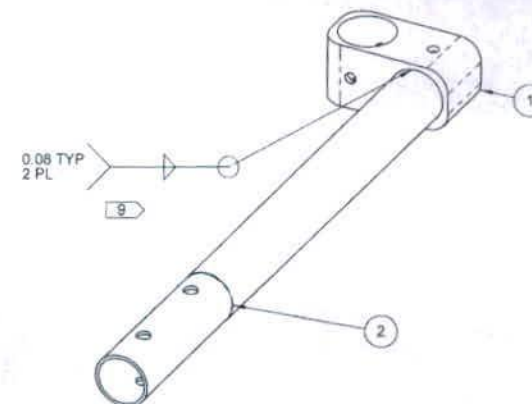
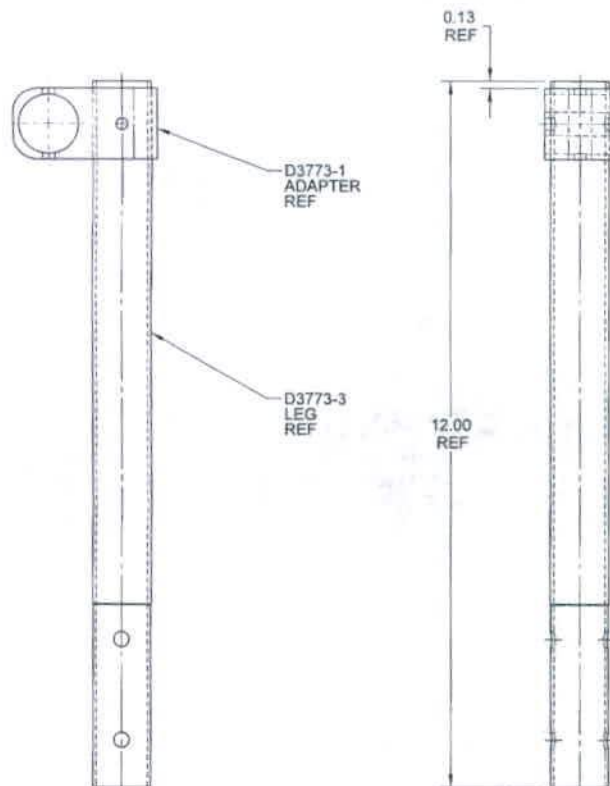
*08/08/25/27*

Job Completion



*u 08.08.25*





ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	D3773-1	ADAPTER	1
2	D3773-3	LEG	1

# NOTES:

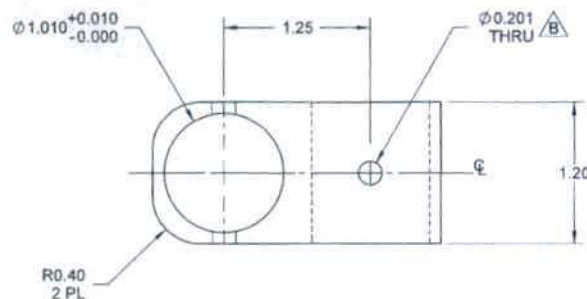
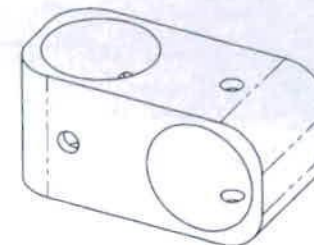
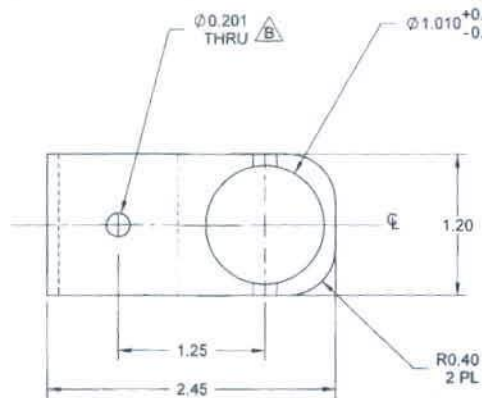
- 1) MATERIAL: SEE D3773-1/-3
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3773-1, 0.40 lbs  
D3773-3, 0.69 lbs  
D3773-041, 1.04 lbs
- 8) WELD: PER DART QSI 004
- 9) IF NECESSARY GRIND INTERIOR OF D3773-3 LEG FLUSH AFTER WELDING

**D3773-041 HEADREST ASSEMBLY**

#40980

B	CHANGE HOLE SIZE TO 0.201	HS	08.06.24
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3773	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	HEADREST ADAPTER	NTS
DATE	08.06.24	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD  THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	





**D3773-1 ADAPTER**

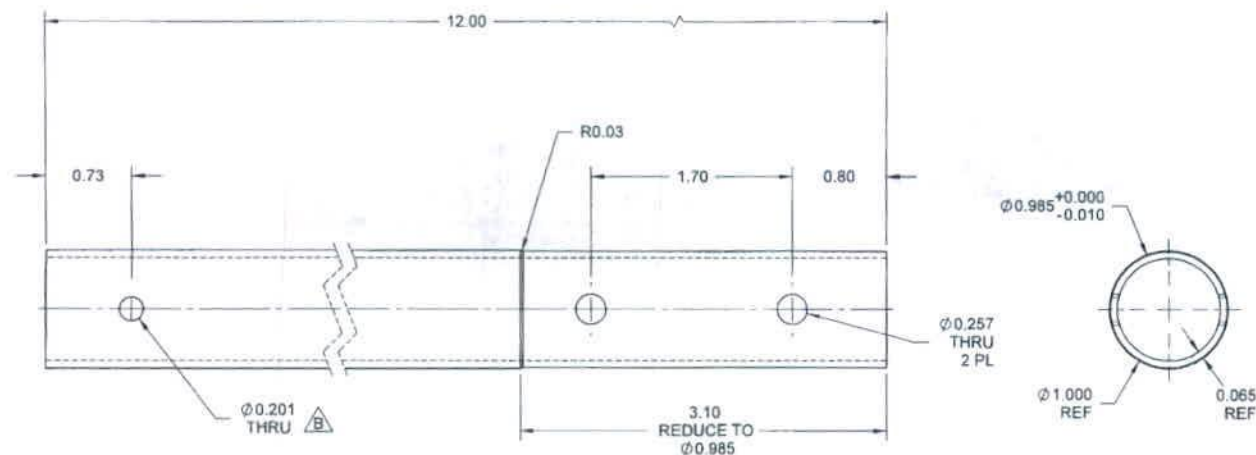
**NOTES:**

- 1) MATERIAL: AISI 304/316 SS BAR (REF DART SPEC M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES. 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs

*Wb 40980*

DESIGN	HS	<b>DART AEROSPACE LTD</b>	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3773	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HEADREST ADAPTER	NTS
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**D3773-3 LEG**

*No 40980*

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS TUBING 1.00" OD X 0.065" WALL (REF DART SPEC M304TR1.000X.065)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3773</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>HEADREST ADAPTER</b>	NTS
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